

Date: Friday, 3/16/2007 1:13:02 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW  
Job Number : 31252  
Estimate Number : 10836  
P.O. Number : N/A Part Number : D29391  
This Issue : 3/16/2007 S.O. No. : N/A Drawing Number : D2939-UNDER REVIEW  
Prsht Rev. : NC Project Number : N/A CB 07.03.16  
First Issue : 3/16/2007 Type : MACHINED PARTS Drawing Revision : N/A  
Previous Run : 30482 Material : N/A  
Written By : Due Date : 3/30/2007 Qty: 8 Um: Each  
Checked & Approved By : 070316  
Comment : Est: B 00.06.26 New DWG rev (mpp.2069) EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 325345 28 070316

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. 0703161-Inspect part number and batch number are programmed correctly. 070326

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 &amp; attached Dimension Sheet

5-Deburr 070327 8

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet 070327 8

4.0

QC1

INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET 070327 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/16/2007 1:13:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER  
REVIEW

Job Number: 31252

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07/03/27 4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h

07/03/27

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/03/28 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CP 04/03/29 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CP 04/03/29 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD 07/03/30

Job Completion



u 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2939-1
<b>Inspection Dwg:</b> D2939 Rev. <i>BC</i>		Page 1 of 1

*CB 07.03.16*

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.121	0.125	0.125	0.125		
B	0.100	0.140		0.121	0.125	0.125	0.125		
C	0.100	0.140		0.132	0.139	0.139	0.139		
D	0.210	0.230		0.220	0.220	0.220	0.220		
E	1.245	1.255		1.246	1.250	1.250	1.250		
F	1.245	1.255		1.246	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.577	1.577	1.577		
J	2.495	2.505		2.497	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.255	0.255	0.259	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.125	0.125	0.125	0.125		
O	0.540	0.560		0.544	0.544	0.544	0.544		
P	0.490	0.510		0.495	0.495	0.495	0.495		
Q	3.715	3.725		3.716	3.720	3.720	3.720		
R	2.720	2.760		2.756	2.740	2.744	2.744		
S	0.240	0.270		0.253	0.253	0.253	0.253		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.259	1.260	1.260		
Y	1.565	1.585	DT8695 A/B						
Z	0.015	0.035		0.025	0.025	0.025	0.025		
AA	6.990	6.990		6.990	6.992	6.992	6.992		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>Er. BSC</i>
Date: <i>07.03.27</i>

Audited by: <i>J.L.</i>
Date: <i>07/03/27</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF <i>RF</i>	<i>#</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2939-1
<b>Inspection Dwg:</b> D2939 Rev. <i>PL</i>		Page 1 of 1

*C3 07.03.16*

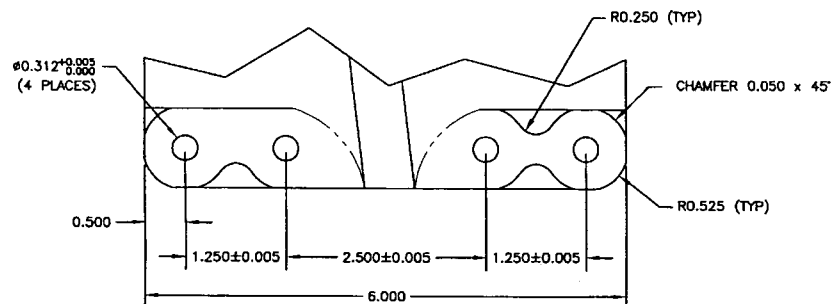
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.135	.135	.135	.135		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.260	.260	.260	.260		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.240	.240	.240	.240		
N	0.100	0.140		.135	.135	.135	.135		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.722	3.722	3.722	3.722		
R	2.720	2.760		3.742	3.742	3.742	3.742		
S	0.240	0.270		.260	.260	.260	.260		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	<del>1.575</del>	<del>1.575</del>	<del>1.575</del>	<del>1.575</del>		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>BC</i>
Date:	<i>07.03.27</i>

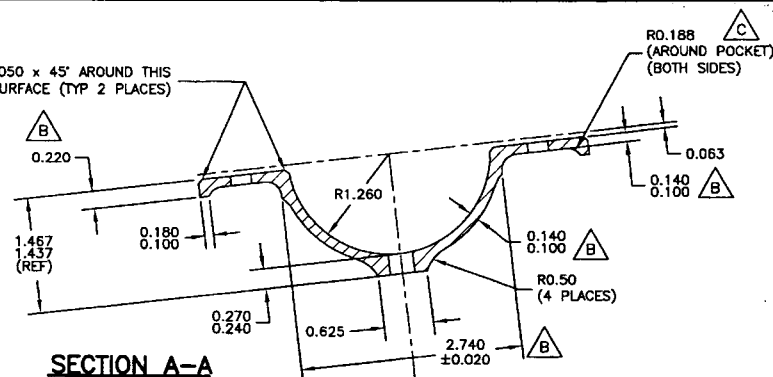
Audited by:	<i>J.L</i>
Date:	<i>07/03/27</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF <i>TH</i>	<i>#</i>



VIEW C-C

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)

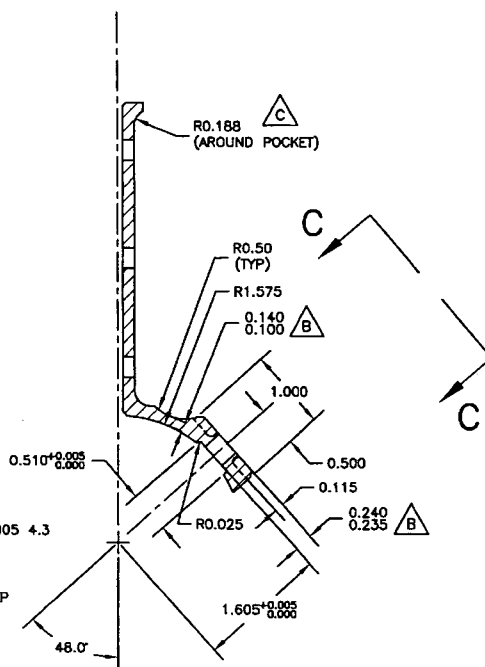


SECTION A-A

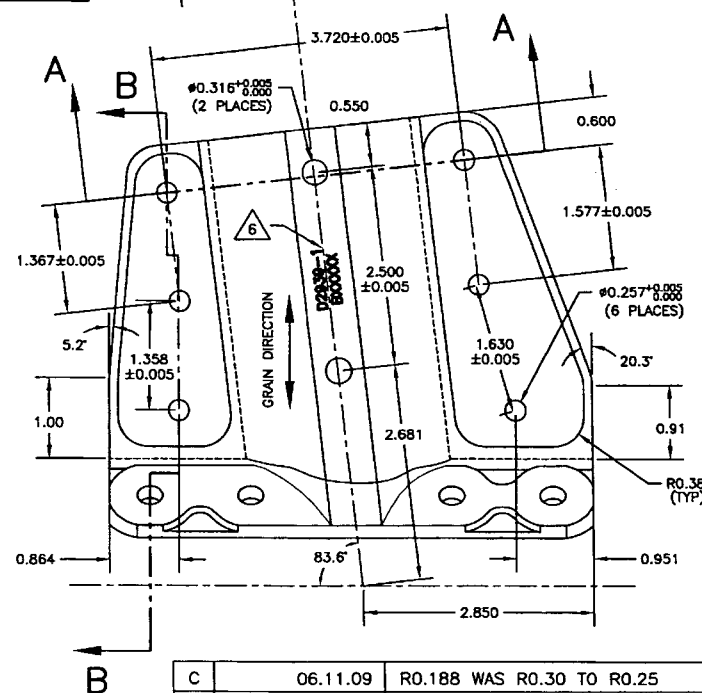
D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		

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CHECKED

APPROVED

DRAWING NO.

D2939

TITLE

SADDLE INSIDE

REV. C

SHEET 1 OF 1

SCALE

2:3

NO. \_\_\_\_\_  
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07.02.12